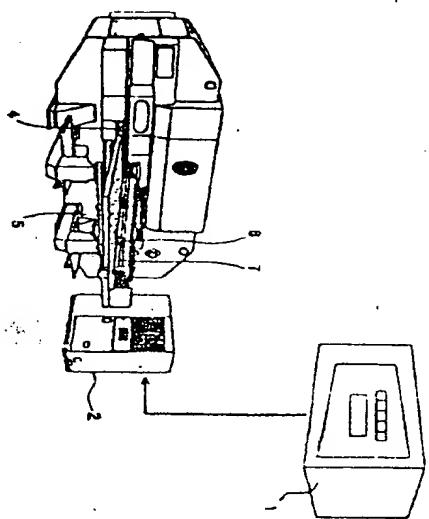


(54) DETERMINATION OF COORDINATE OF TAKEN-OUT PATTERN OF TESTPIECE

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PURPOSE: To automatically take out a testpiece efficiently from a sample member by setting a zone on the basis of the regulation for a testpiece to be taken out from a sample member and determining the coordinates of the taken-out pattern on the basis of the coordinate supplied from a basic point set in the zone.

CONSTITUTION: Sample members can be divided into plural groups (zone=taking-out enabled region) on the basis of the shape and attributes. When the kind of the punching-out test of an objective sample member is inputted into an upper rank calculator 1, the zone is selected for each test piece in an upper rank calculator 1. The zone, test piece kind, and size selected by the calculator 1 are transmitted as the instruction which is characteristic for the sample member to an NC controller 2. The standard coordinate of the zone stored in the NC controller 2 and the instruction supplied from the calculator 1 are allowed to correspond, and the absolute punching-out coordinate of each testpiece is determined, and at the time, the punching-out order is determined, and punching-out is executed by a turret punch. The efficient taking-out of a testpiece from the sample member is made possible carrying out the punching-out of the testpiece through these procedures.



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